

Work Order ID 130285

March-04-15 7:50:34 AM

130285

Page 1

Item ID: 647.7703

Revision ID:

Item Name: Strut Assembly

Start Date: 3/04/15 Start Qty: 5.00

Required Date: 3/13/15 Req'd Qty: 5.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.7700

A

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

5 Q 15-3-5

120

Weld per dwg A/R 4130 rod Batch: 4127925 0.00***120***

Large Fab

Memo

0.00

Large Fab

1- ASSEMBLE AND WELD AS PER DWG

***IMPORTANT DIMENSION IS 8.35" ***

5 Q 15-3-5

130

QC9- Inspect visual per QSI004- Fusion Welds 0.00

130

QC

Memo

0.00

Quality Control

5 15-03-05

DAG
9
9-89

March-04-15 7:50:34 AM

Item ID: 647.7703

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Assembly

Stop *NS2*

Start Date: 3/04/15 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 3/13/15 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	QC5- Inspect part completeness to step on W/O	0.00
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140

QC	Memo	0.00
----	------	------

Quality Control

⑤ 15-03-06 DAS
9
9-89

150	Outsource process-Cadplate per QSI017 4.1.9.1	0.00
-----	---	------

150

Outsource3	Memo	0.00
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Outsource process - Cad plate

Memo

Issue P/O : 27692
C of C is required

CL 15/03/06 (5)

160	Receive & Inspect for Damage & Mat'l Certs	0.00
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160

Packaging	Memo	0.00
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Packaging

5x Sp15-03-23

Work Order ID 130285

130285

Page 4

March-04-15 7:50:34 AM

Item ID: 647.7703 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Assembly
 Start Date: 3/04/15 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 3/13/15 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>CC12</u>	0.00				5x		DAS 26 9-89	MAR 31 2015
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

DIS.3-31

Picklist Print

March-04-15 7:50:33 AM

Page 1

Work Order ID: 130285

130285

Parent Item: 647.7703

647 7703

Parent Item Name: Strut Assembly

Start Date: 3/04/15

Required Date: 3/13/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7712		Manufactured	No				Each	5.0000		5			
647 7712										**	EL 15-3-4		
Strut Tube													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CCK113		5							
				94061		5							
647.7713		Manufactured	No				Each	7.0000		5			
647 7713										**	EL 15-3-4		
Strut Thread													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CCK113		7							
				128260		7							
647.7714		Manufactured	No				Each	0.0000		5			
647 7714										**	EL 15-3-4		
Strut Tube													

13029245

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 04741			SHEET 1 OF 1	
	DWG NO. 647.7700	REV: NC	PREPARED BY J. SOTO	DATE: 11/13/2014	EFFECT ON DWG ☒ INC. ☐ UNINC.
	DWG TITLE: STRUT ASSY				
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: CREATED NEW CONFIGURATION. ADDED F/N 5.				

uq 30285

5	A	647.7714	1	STRUT TUBE	△	
4	R	647.7713	1	STRUT THREAD	△	△
3	R	647.7712	1	STRUT TUBE	△	
	C	647.7703	X	STRUT ASSY		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
		7703				

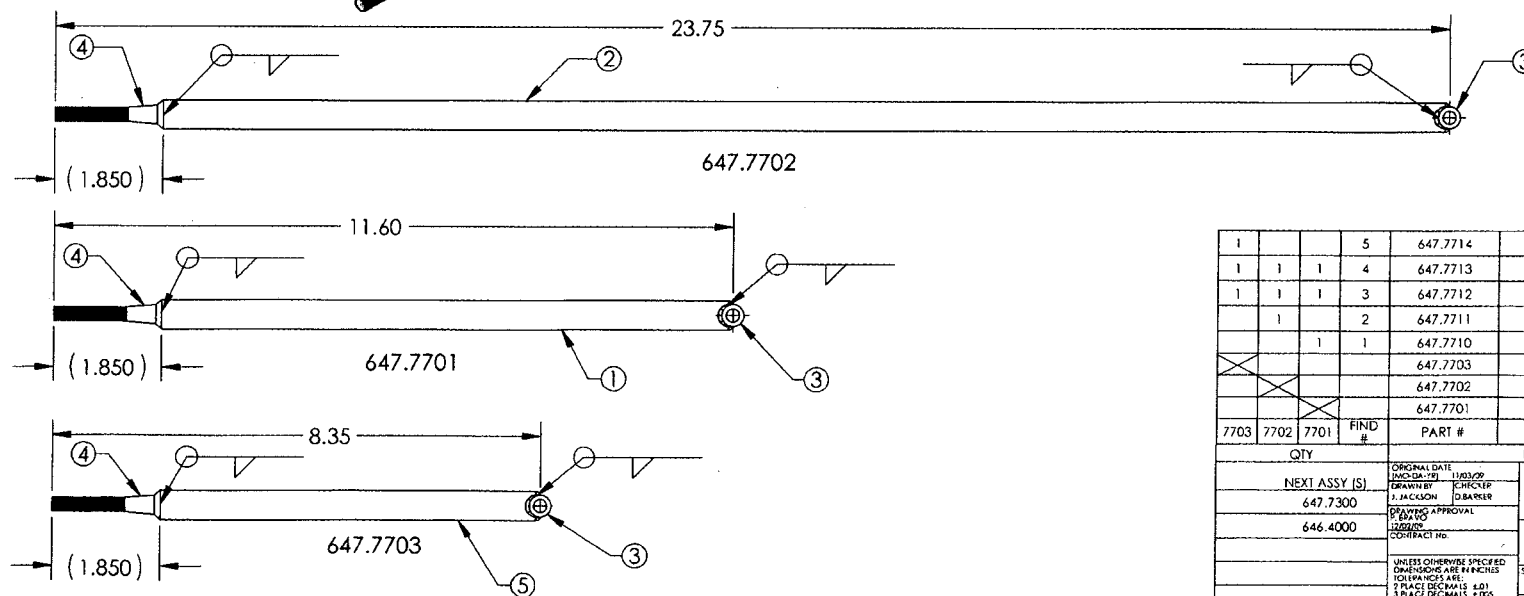
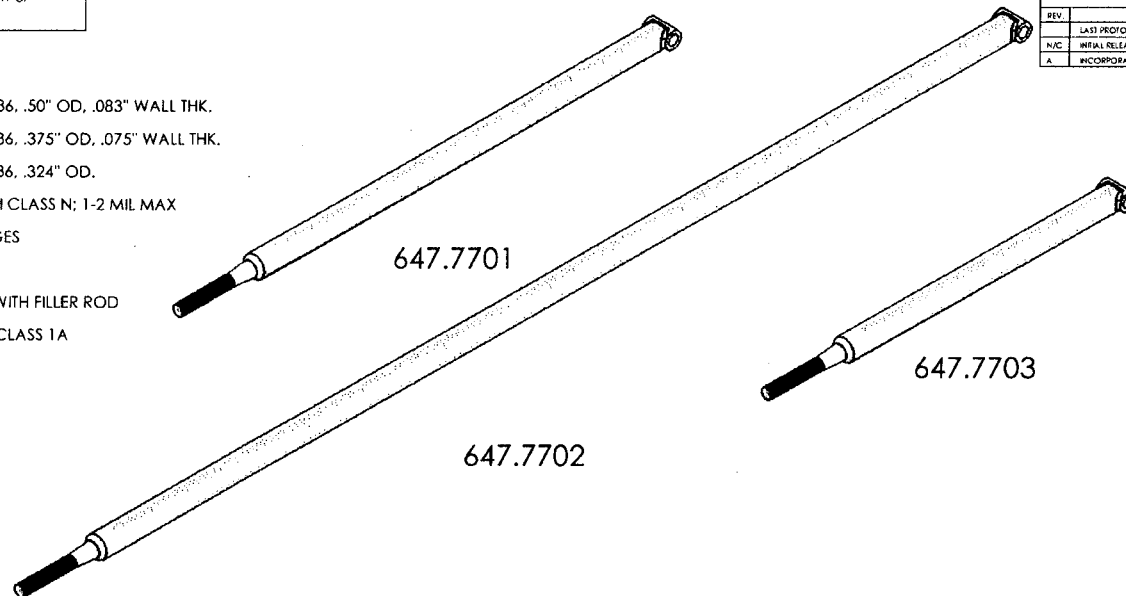
DOCUMENTS EFFECTED:	☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO
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NOTES:

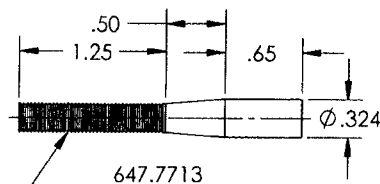
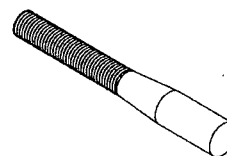
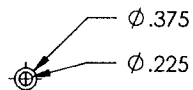
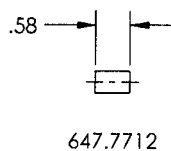
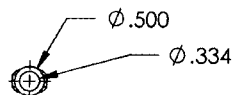
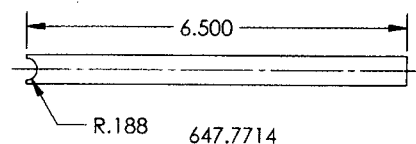
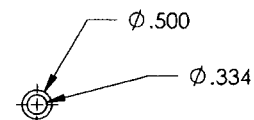
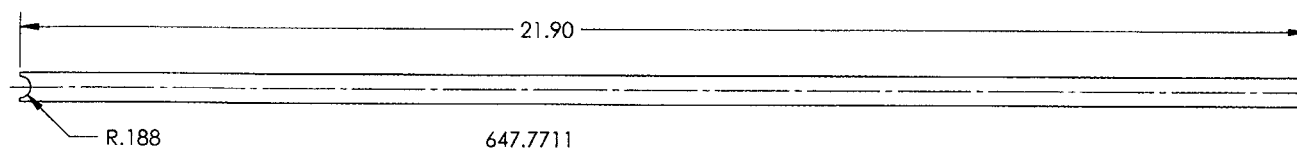
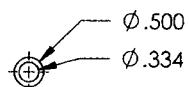
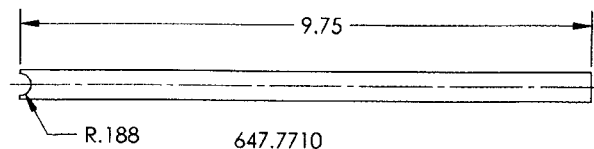
- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES
- 6 IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
- 9 MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION PP2		N/C
2	INITIAL RELEASE	12/05/09	P. BRAYO
3	INCORPORATED ICH 04741	11/13/14	P. BRAYO



1			5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
	1		2	647.7711	STRUT TUBE	△	
		1	1	647.7710	STRUT TUBE	△	
				647.7703	STRUT ASSY		△△
				647.7702	STRUT ASSY		△△
				647.7701	STRUT ASSY		△△
7703	7702	7701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE JACKSON J. JACKSON DRAWN BY J. JACKSON CHECKED D. BARKER DATE OF APPROVAL DATE OF ISSUE CONTRACT NO. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5° SEE CAGE CODE DWG NO. B 07M26 647.7700 SCALE NONE SHEET 1 OF 2			
647.7300							
646.4000				STRUT ASSY			

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1/4 - 28 THREAD

FORMAL DATE
1/10/01
DRAWN BY J. JACKSON
CHECKED J. JACKSON
DRAWING APPROVAL P. BRAY
CONTRACT NO.
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300
STRUT ASSY
REV. A
SCALE: NONE
SHEET 2 OF 2



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27692**

Purchase Order Date 3/6/2015

PO Print Date 3/6/2015

Page Number 1 of 2

Order From :

VC-CAD002

Ship To : DART AEROSPACE LTD

CADORATH COATING
2150 LOGAN AVE.
WINNIPEG, MB R2R 0J2
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 204 633 9420

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	130285	647.7703 STRUT	3/13/2015 Yes 3/13/2015		5.00 ✓	\$0.00	\$0.00
	FINISH: CAD PLATE AS PER QQ-P-416F CLASS 1, TYPE II						
5015-03-23 Line Total:							\$0.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	3/13/2015 No 3/13/2015		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A021 dart aerospace processing A024 process certifications A026 certification of material conformance A043 retention of quality documents						

Note:

3/6/2015

Packing Slip



Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

S76006

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Sold To:

Dart Aerospace Ltd.
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

ShipTo:

Customer Order #: 27692

Date Received: Mar-16-2015

Terms:

NET 30 DAYS

G.S.T. #:

10071 6547 RT0001

Ship Via:

Ship Date:

Mar-20-2015

Item # Qty P/N & Description

1 ✓ 5 EA STRUT
P/N 647.7703

S/N
W/O 145299

2015-03-23

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Mar-20-2015

**CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7**

W/O #: 145299

INVOICE #: 76006

**CONTRACT OR
PURCHASE ORDER # 27692**

DESCRIPTION: STRUT

QTY 5

P/N # 647.7703

S/N #

**STRIP IAW MIL-STD-871. CADMIUM PLATE IAW AMS QQ-P-416C
TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 15-248.**

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:

